Date:

Tuesday, 05/09/2006 10:35:36 AM

User:

Linda Lacelle

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28409

Estimate Number

: 11264

P.O. Number

AIG:

: 05/09/2006 This Issue

: NC

: 26084

S.O. No. : >10A

: 01/09/2006

First Issue **Previous Run**

Written By

Prsht Rev.

Checked & Approved By Comment

: Est Rev:A New Issue

: MACHINED PARTS

05-12-06 JLM

Material **Due Date**

Description:

Drawing Name

Part Number

Drawing Number

Project Number

Drawing Revision

; N/A

: D3276041

: D3276 REV B

: 20/09/2006

...: BAFFLE ASSEMBLY

Qty:

10 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

1.0

M6061T6S040

6061-T6 .040 Sheet



Comment: Qty.:

1.0715 sf(s)/Unit Total: 10.7153 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.040" thick

(M6061T6S.040)

Batch: 1/1007

2.0

Comment: FLOW WATER JET 3.0 QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

Comment: SECOND CHECK

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

SAD 06509510 10

2-Roll as per Dwg D3276



Tuesday, 05/09/2006 10:35:36 AM Date: Linda Lacelle User: **Process Sheet** Drawing Name: BAFFLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 28409 Part Number: D3276041 Job Number: Seq. #: Description: Machine Or Operation: BRAKE NC NC BRAKE 6.0 Comment: NC BRAKE Form as per Dwg D3276, check with template DT8825 10 INSPECT WORK TO CURRENT STEP 7.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING1 HAND FINISHING RESOURCE #1 8.0 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 POWDER COATING 9.0 POWDER COATING M. W Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 a.m INSPECT POWDER COAT/CHEMICAL CONVERSION 10.0 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 Comment: Qty.: 2.2500 f(s)/Unit Total: 22.5000 f(s) Pick: Description Batch **Qty Part Number** 06-10-18 27.0" D2464 Neoprene Seal 12.0 D32763 Comment: Qty.: 10.0000: Each(s) 1.0000 Each(s)/Unit Total: Pick: Batch 25228 x5/ B28810 x5 66.10.10 **Qty Part Number** Description Batch 1 D3276-3

Date: User:

Tuesday, 05/09/2006 10:35:36 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BAFFLE ASSEMBLY

Job Number: 28409

Part Number: D3276041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3276



06-10-18

W

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



DC 16.0



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Friday, 9/1/2006 12:17:24 PM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number** : 28409 : 11264

P.O. Number

: 9/1/2006 This Issue

: NC Prsht Rev.

First Issue

: 11 : 26084

S.O. No. :

Type

: MACHINED PARTS

Part Number

Drawing Name

: D3276041

Drawing Number

: D3276 REV B

: BAFFLE ASSEMBLY

Project Number

: N/A

Drawing Revision

; B

Material

Due Date

: 9/20/2006

Qty:

10 Um:

Each

Written By

Previous Run

Checked & Approved By Comment

: Est Rev:A

New Issue

JLM 05-12-06

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

2.0

M6061T6S040

6061-T6 .040 Sheet

Comment: Qty.: 1.0715 sf(s)/Unit Total:

Material: 6061-T6 (QQ-A-250/11) 0.040" thick

(M6061T6S.040)

Batch:

SHEAR

10.7153 sf(s)

SHEAR

Comment: SHEAR

Cut blank: 8.975" x 16.375" grain along 8.975"

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1







Identify as D3276-1

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE







Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8



SECOND CHECK



Comment: SECOND CHECK

Dart Ae	rospace l	Ltd							
W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PROCEDURE CHANGE		NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
	·								
Part No		PAR #:	Fault Cate	Jory:					
			MODIC ODDI	D NON CONFORMAN				_ Date:	
NCR:			WORK ORDE	ER NON-CONFORMAN	CE (NCR)				
DATE	STEP	Description of NC		Corrective Action Section		Verificat	tion	Approval	Approval QC Inspector
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	

NOTE: Date & initial all entries

Friday, 9/1/2006 12:17:24 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: BAFFLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Job Number: 28409 Part Number: D3276041 Job Number: Seq. #: Description: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 6.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr 2-Roll as per Dwg D3276 NC BRAKE 7.0 Comment: NC BRAKE Form as per Dwg D3276, check with template DT8825 INSPECT WORK TO CURRENT STEP 8.0 QC5 Comment: INSPECT WORK TO CURRENT STEP 9.0 HAND FINISHING1 HAND FINISHING RESOURCE #1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 10.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 11.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION 12.0 D2464

2.2500 f(s)/Unit

Total: 22.5000 f(s)

Pick:

Comment: Qty.:

Qty Part Number

Description Batch

27.0" D2464

Neoprene Seal

Dart Aerospace Ltd

									
W/O:			WC	ORK ORDER CHANG	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	jory:	_ NCR: Yes	No DQ	\ \ :	Date: _	
								Date:	
NCR:		,	WORK ORDE	ER NON-CONFORM	ANCE (NCR	2)			
D.4.T.E	2750	Description of NC Corrective Action			Section B		ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		Section C	Chief Eng	QC Inspector

NOTE: Date & initial all entries

Friday, 9/1/2006 12:17:24 PM Date: Kim Johnston **User: Process Sheet** Drawing Name: BAFFLE ASSEMBLY Customer: CU-DAR001 Dart Helicopters Services Part Number: D3276041 Job Number: 28409 Job Number: Seq. #: Description: **Machine Or Operation:** 13.0 D32763 Decal 10.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Pick: **Qty Part Number** Description Batch 1 D3276-3 Decal SMALL & MEDIUM FAB RESOURCE 1 SMALL FAB 1 14.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D3276 INSPECT WORK TO CURRENT STEP 15.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING 1 PACKAGING RESOURCE #1 16.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_ DOCUMENT CONTROL 17.0 DC Comment: DOCUMENT CONTROL Inspection Level 21 Job Completion

Dart Aerospace Ltd

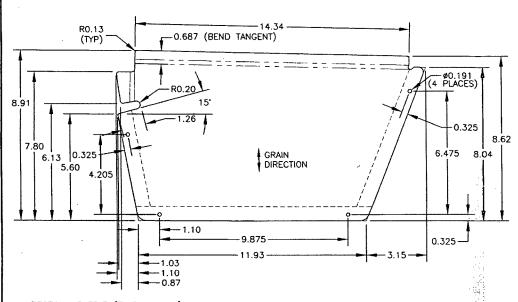
Duitho	·oopaoc	Lu								
W/O:			WC	RK ORDER CHANG	SES					
DATE	STEP	PR	OCEDURE CHAI	CEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cateç	Jory:	_ NCR:	Yes N	lo DQ	A :	Date:	
					C)A: N/	C Close	d:	Date:	
NCR:		,	WORK ORDE	ER NON-CONFORM	ANCE (NCR)				
DATE	STEP	Description of NC	Corrective Action Section B			Verification		ation	Approval	Approval
DATE	SILF	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
								i		
									-	
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					·					
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28409
Description: Baffle	Part Number:	D3276-1
Inspection Dwg: D3276 Rev: B		Page 1 of 1

	Г						
		First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
14.34	+/-0.030	14.36	V		Moiasunin	a tap	و
8.62	+/-0.030	8.688	V		vern) ' ı	
8.04	+/-0.030	8.049	V		Veris		
Ø0.191	+0.005/-0.000	0.194	\ \		Vern		
0.325	+/-0.005	0.321	V .		VEIN		
11.93	+/-0.030	12.016	V		vern		
9.875	+/-0.005	9.880	/		VerN		
5.60	+/-0.030	5.64	V		Veril		
7.80	+/-0.030	7.79	/		VerN		
8.91	+/-0.030	8.91	/		verN		
1.26	+/-0.030	1.23			VERN		
Grain Direction	N/A						
Measured by: ,	M. M/ N 09 06	Audited by:		5.06	Prototype App	proval:	N/A N/A

Rev	Date	Change		Revised by Approved	╛
Α	05.04.26	New Issue	P/O D044-717-011	KJ/JLM SH SM	
				——— () / /	



D3276-1 BAFFLE (FLAT PATIERN)

1) MACHINE PER DWG FILE "D3276-A.DWG"

2) MATERIAL: 6061-T6 ALUMINUM 0.040 THICK (QQ-A-250/11)

(REF DART SPEC. M6061T6S.040)

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

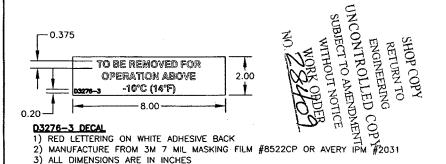
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3

4) ALL DIMENSIONS ARE IN INCHES

3) ALL DIMENSIONS ARE IN INCHES

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



0.72 -D3276-3 DECAL SECTION A-A JOGGLE DETAIL 0.23 (ON THIS SIDE -041, -042 OPPOSITE, CENTERED ON PART) -D3276-1 BAFFLE 0.63-(BEND DOWN -041, BEND UP -042) R0.13 **JOGGLE** -R0.13 TO BE REMOVED FOR **OPERATION ABOVE** -10°C (14°F) 2.4 D2464-0270 NEOPRENE SEAL (ON UNDERSIDE -041, -042 8.0 OPPOSITE, TRIM TO FIT)

D3276-041 BAFFLE ASSEMBLY, LH (SHOWN)
D3276-042 BAFFLE ASSEMBLY, RH (BEND/JOGGLE OPPOSITE)



	В	05.01.25	LABEL NOW -10	C; CURVE PART	ĺ
	A	05.01.07	NEW ISSUE		
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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE	CHECKED	APPROVED	DRAWING NO. D3276	REV. B SHEET 1 OF 1	
OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	05.01.25	i per	TITLE BAFFLE ASSEMBLY	SCALE Y 1:3	